

Date: Tuesday, 12/5/2006 8:12:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/355 AS X-TUBE AFT
Job Number : 29765	
Estimate Number : 12486	
P.O. Number :	Part Number : D350748201
This Issue : 12/5/2006 S.O. No. :	Drawing Number : IIN-D350-748 PG5
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : A UNDER REVIEW OK 06/11/05
Previous Run : 29764	Material :
Written By :	Due Date : 1/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>061205</u>	
Comment : Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update qty of MS21042L5 06-09-12 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT-CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

2.0	29765A	X-TUBE AS 350/355 HI-AFT
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Comment: Sub-Component X-TUBE AS 350/355 HI AFT
 D350-748-241 B 29765A

7/6/24 S9

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 350 SADDLE
 Batch: B28477 ✓

5.0	D35011	BUSHING
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
 BUSHING
 Batch: B29799 ✓

2/6/15 S9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29765

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M103962 X

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M102552 X

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102115 X

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M103696 X

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M103641 X

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M102552 X

12.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M102536 X

7/6/5 sq

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:12:53 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 29765

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/6/7 *① 207106107 ①*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: _____

PPP Rev: _____

Rev A

7/6/14 SQ AU

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-06-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.10 Apply a continuous bead of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant in the following locations as per Figure 6:

- A) Along saddle/crosstube interface.
- B) Between the saddle flanges.
- C) Along saddle/skidtube interface.

4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/AFT	WEIGHT	STA	MOMENT
D350-748-101	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29765

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Revision: A

Date: 06.05.08

Date: Tuesday, 12/5/2006 8:12:52 AM
User: Kim Johnston

Process Sheet

5, 2007

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Estimate Number : 12486
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Previous Run : 29764
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Project Number : N/A
Drawing Revision : A ~~UNDER REVIEW~~ OK 06/11/05
Material :
Due Date : 1/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

07.01.18

2.0 29765A X-TUBE AS 350/355 HI AFT



Comment: Sub-Component X-TUBE AS 350/355 HI AFT
D350-748-241 B

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0 D35001 350 SADDLE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
350 SADDLE
Batch: _____

5.0 D35011 BUSHING



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
BUSHING
Batch: _____

REFERENCE ONLY

